



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9711

Job Sheet 181423



Part No: 646.9711

Job Qty: 120 ea

Part Name: Blade



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E SHEETS 1,5 IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup hrs	Run Hrs		
90	Start up Operation	120 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Machining-1	
100	Bandsaw	120 pcs	9/10/18	9/10/18	0.00	3.74	Bandsaw1	DAS 54 9-89
110	CNC Vertical Machining	120 pcs	9/10/18	9/10/18	0.13	120.00	HAAS1-1	
120	QC	120 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Machining-1	
130	QC	120 pcs	9/10/18	9/10/18	0.00	0.00	QC8 Machining-1	
140	Outsource	120 pcs	9/10/18	9/10/18			MEI001-VC 10	
150	Packaging	120 pcs	9/10/18	9/10/18	0.00	0.00	Packaging2	
155	QC	120 pcs	9/10/18	9/10/18	0.00	0.00	QC56	
160	SprayPaint	120 pcs	9/10/18	9/10/18	0.00	4.00	Spray Paint	
170	QC	120 pcs	9/10/18	9/10/18	0.00	0.00	QC14	
180	Packaging	120 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1	
190	QC21-SA	120 Ea	9/10/18	9/10/18	0.00	0.00	QC21	

Part Op 100 - Cut Blank at 4.625"

Descriptions: 110 - 1-Machine per folio FB135

140 - PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2

TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED

160 - ***THIN COAT OF PRIMER*** PRIME AS PER DWG, SEE NOTE #4

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	46.3200 ft (.386 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MSTEEL-A2-B0.500X1.250	46	8	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	0.340Inches	+ 0.000 - 0.005	0.340 0.335	
2	Blade	0.177Inches	+ 0.005 - 0.001	0.182 0.176	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected/Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____			MRB (QSI042) Approval		
Part: 646.9711 Job No: 181423 Serial No/Batch: S104600 Revision: E Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/23/18 DART AEROSPACE Container No: S104600 1270 Aberdeen Street Haverhill, MA 01830 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Environmental Design Doc/Dat Equip/Toolin Handling/Pr Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified	Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter </td> <td style="width:50%; vertical-align: top;"> Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes </td> </tr> </table>			Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes
Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes					
OTHER : _____		<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center </td> <td style="width:50%; vertical-align: top;"> ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> </tr> </table>			CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence					

3	Blade	3.200Inches $\pm$ 0.005	3.205 3.195
4	Blade	0.600Inches $\pm$ 0.005	0.605 0.595
5	Blade	0.985Inches $\pm$ 0.005	0.990 0.980
6	Blade	2.400Inches $\pm$ 0.005	2.405 2.395
7	Blade	1.200Inches $\pm$ 0.005	1.205 1.195
8	Blade	0.250Inches $\pm$ 0.005	0.255 0.245
9	Blade	37.2Angle $\pm$ 0.5	37.7 36.7
10	Blade	0.290Inches $\pm$ 0.010	0.300 0.280
11	Blade	30.0Angle $\pm$ 0.5	30.5 29.5

Plex 7/26/18 8:35 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																				
Large Fab ☐	Composite ☐	Supplier ☐																																																																					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																																
Description Work Order Deviation				Disposition				Completed By																																																															
								Lead hand / Supervisor Approval Verification																																																															
								QC / QA Coordinator Approval																																																															
Root Cause <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verification ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>				Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Pressure/Forced ☐</td> <td style="width:15%;">Temperature/Cure ☐</td> <td style="width:15%;">Power Loss/Surge ☐</td> <td style="width:15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																																						
Design ☐	Operator ☐																																																																						
Doc/Data ☐	Offset/Setup ☐																																																																						
Equip/Tooling ☐	Supplier ☐																																																																						
Handling/Pre ☐	Training ☐																																																																						
Material ☐	Use for Testing ☐																																																																						
Internal Transport ☐	Poor Information ☐																																																																						
Tribal Knowledge ☐	Rushing ☐																																																																						
LOA ☐	Product Improvement ☐																																																																						
Substation ☐	Process Improvement ☐																																																																						
Past Expiry Date ☐	Manufacturing Process ☐																																																																						
Misidentified ☐	Past Due ☐																																																																						
Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																				
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																				
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																				
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																				
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																				
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																				
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																				
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																				
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																				
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																				
				OTHER :																																																																			

DART AEROSPACE LTD		Work Order:	181423
Description: Blade		Part Number:	646.9711
Inspection Dwg: 646.9700 Rev: D2			Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	94 9-89	Checked by:		QC Inspector:	
Date:	18/08/15	Date:		Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	13.06.03	New Issue	KJ	
B	13.06.27	Dwg Rev updated	KJ	
C	13.07.18	Dwg Rev updated	KJ	
D	13.08.23	Dimensions revised	KJ	
E	13.11.26	Dwg Rev updated	KJ	
F	16.05.27	Dwg Rev updated	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040852

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040852
PO Date: 8/27/18
Due Date: 9/14/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180721	4.5NR-10	Lock Roller Pin 1-Issue P/O to Metcore ; P/O RC 50-55 2-Bead blast 3--Material type ; 01 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER METCORE to ship directly to GROUPE ALTECH ***	Firmed	-	9/14/18	5 pcs	0 pcs	5 pcs	\$0.01/pcs	\$0.05

Line Item Note ** rush need asap **

CC

Plex 9/12/18 3:42 PM dart.tsimiklis.chrisoula



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040852

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	181423	646.9711	Blade PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	-	9/14/18	120 pcs	0 pcs	120 pcs	\$2.166666/pcs	\$260.00
Grand Total:											\$260.05

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/12/18 3:42 PM dart.tsimiklis.chrisoula

DAS
38
9-89

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
330032	1	130690

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
40852		A2	2018/8/30	pick up

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
120	646.9711		DAS	33,
	(120) 646.9711		61	
	JOB 181423		9-89	

2 = 1 B.B + 1 VALISE

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
	2	2=1 B.B + 1 VALISE

certificat

EMPAQUETAGE Packing	
-------------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 120
POIDS EXPÉDIÉ / Weight Shipped : 33,00
QUANTITÉ RESTANTE / Quantity Remaining : 0
POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

certificat

QUANTITÉ EXPÉDIÉE / Quantity Shipped:	120
POIDS EXPÉDIÉ / Weight Shipped :	33,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2018/09/10

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
330032	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40852	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	5	61 - 62 HRC

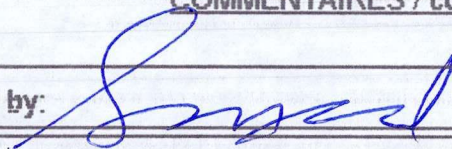
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
120	33	846.9711 (120) 846.9711 JOB 181423 2 = 1 B.B + 1 VALISE

DAS
61
9-89

14/9/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-09-09

APPROUVÉ

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
330032	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40852	N/A	A2		
<u>SPÉCIFICATIONS DU PROCÉDÉ</u> processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC		5	61 - 62 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
120	33	646.9711 (120) 646.9711 JOB 181423 2 = 1 B.B + 1 VALISE		

COMMENTAIRES / comments

VAC HARDEN 1800F, 1HR 30MIN
DOUBLE TEMPER 400F, 2HRS

DAS
38
9-89

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

This document and any attached documents may contain confidential or proprietary information and may be subject to export control laws and regulations. If you are not the intended recipient, you are notified that any dissemination, copying of this e-mail and any attachments thereto or use of their contents by any means whatsoever is strictly prohibited. Unauthorized export or re-export is prohibited.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

APPROUVÉ par / Approved by:

Vincent Costello



DATE: 2018-09-12

METCOR INC.

860 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
330032	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40852	N/A	A2		

SPECIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPECIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	5	61 - 62 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
120	33	648 9711 (120) 648 9711 JOB 181423
		2 = 1 B.B + 1 VALISE

14/9/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

METCOR
7

DATE: 2018-09-09



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041263**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041263

PO Date: 10/4/18

Due Date: 10/5/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181381	646.3015	Blade	Firmed	007 09 2018	10/5/18	50 pcs	0 pcs	50 pcs	\$10.00/pcs	\$500.00
2	182625	647.4311	RH Lower Strut	Firmed	-	10/5/18	10 pcs	0 pcs	10 pcs	\$10.00/pcs	\$100.00
3	181423	646.9711	Blade	Firmed	-	10/5/18	120 pcs	0 pcs	120 pcs	\$10.00/pcs	\$1,200.00
4	179157	646.3511	Strut	Firmed	-	10/5/18	12 pcs	0 pcs	12 pcs	\$10.00/pcs	\$120.00
5	179156	646.3510	Strut	Firmed	-	10/5/18	12 pcs	0 pcs	12 pcs	\$10.00/pcs	\$120.00
Grand Total:										\$2,040.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/9/18 12:52 PM dart.lavoie.chantal